

Date: Wednesday, 11/7/2007 8:18:52 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 35597	
Estimate Number : 11028	
P.O. Number : <i>N/A</i>	Part Number : D28022
This Issue : 11/7/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2802 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>MA</i> Type : MACHINED PARTS	Drawing Revision : <i>A</i>
Previous Run : 29688	Material : <i>N/A</i>
Written By : <i>JLM 07-11-07</i>	Due Date : 11/14/2007
Checked & Approved By : _____	Qty: 8 Um: Each
Comment : Est.B 02.03.18 Re-format NG	
Est.C 06.02.13 Removed p/c EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5750 f(s)/Unit Total : 42.6000 f(s)  
 6061-T6 Bar .50" x 6.0" 14.175  
 Material: 6061-T6 bar 6.00" x 0.50"  
 Batch: *M106027X4 M 105145X5 JLM 07/11/07* (9)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks 17.800" long

*JLM 07/11/07* (9)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio FA101  
 Counter sink .375 dia as per dwg

*JLM 07/11/10* 9

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JLM 07/11/10* 9

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*JLM 07-11-10* (9)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35597

Part Number: D28022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr NO sharp edges.

*JML 07/11/12* (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JML 07-11-12* (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *INT*

*LEO 11-15* 9

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*2011/12/15* (9)

Job Completion



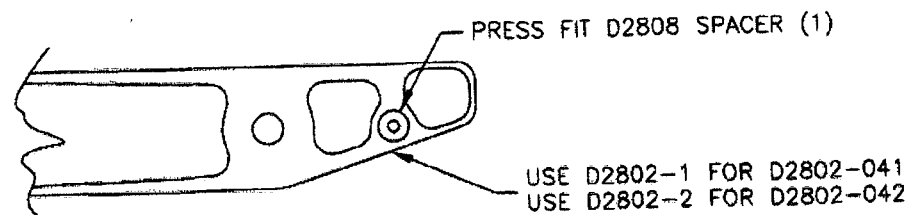
*u 11/11/15*

**DART**

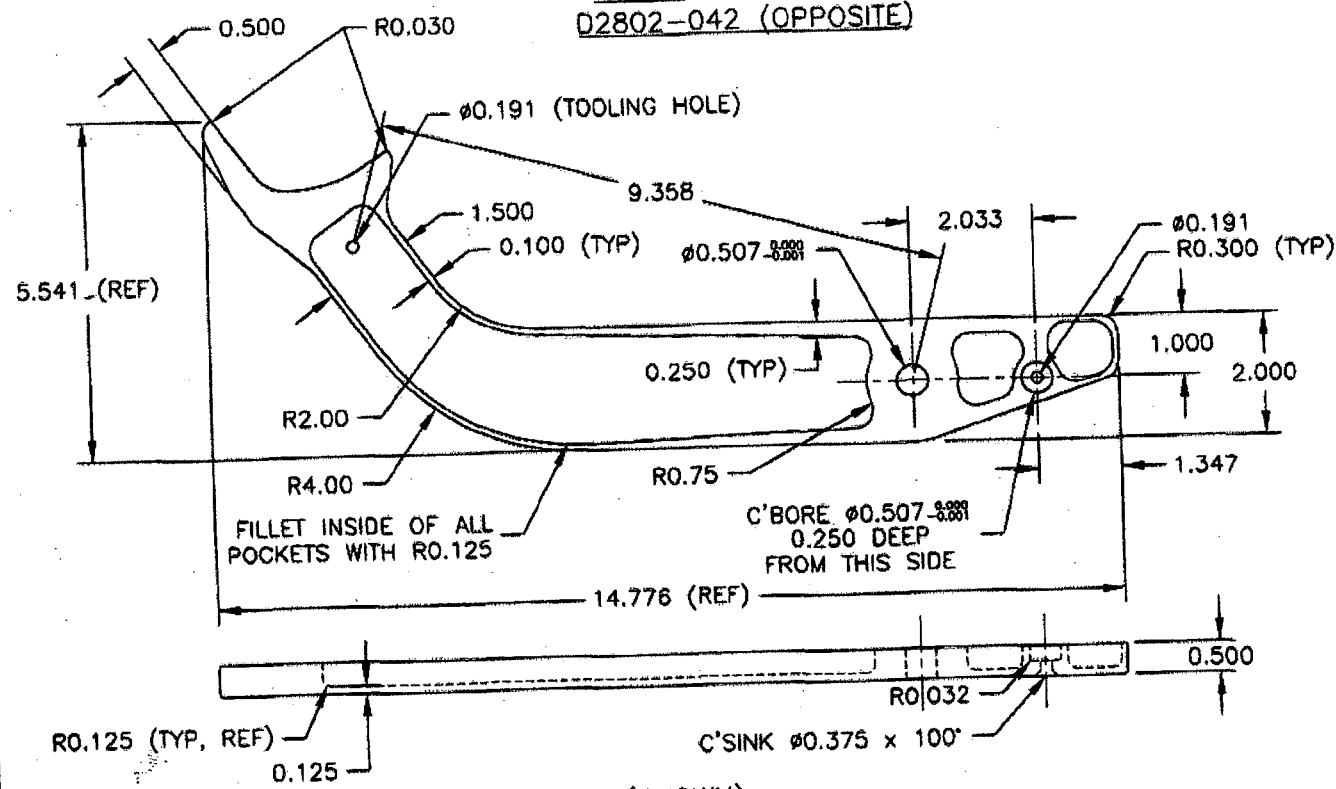


DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAMMERSBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
CP	CP	D2802	SHEET 1 OF 1
DATE	TITLE	ARM	SCALE
00.11.03	ARM		1:3
A	00.11.03	NEW ISSUE	

RELEASED  
00-11-13



D2802-041 (SHOWN)  
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)  
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"  
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)  
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Arm</b>		<b>Part Number:</b>	<b>D2802-2</b>
<b>Inspection Dwg: D2802</b>	<b>Rev: A</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.493"	✓			
Ø0.191	+0.005/-0.001	Ø .191"	✓			
1.500	+/-0.010	1.507"	✓			
0.100	+/-0.010	.104"	✓			
9.358	+/-0.010	9.358"	✓			
Ø0.507	+0.000/-0.001	Ø .507"	✓			
2.033	+/-0.010	2.033"	✓			
1.000	+/-0.010	1.005"	✓			
2.000	+/-0.010	2.007"	✓			
1.347	+/-0.010	1.350	✓			
R0.75	+/-0.030	R0.75"	✓			
R0.300	+/-0.010	R .300	✓			
R0.125	+/-0.010	R .125"	✓			
0.500	+/-0.010	.50"	✓			
0.125	+/-0.010	.120"	✓			
Ø0.507 x 0.250	+0.000/-0.001 x +/-0.010	Ø .506" x .254"	✓			
Ø0.375 x 100°	+/-0.010 x 0.5°	Ø 0.380 x 100°	✓			
0.250	+/-0.010	.249"	✓			
R0.032	+/-0.010	R .032"	✓			

<b>Measured by:</b>	J.F.
<b>Date:</b>	07/11/09

<b>Audited by:</b>	[Signature]
<b>Date:</b>	07/11/10

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	[Signature]